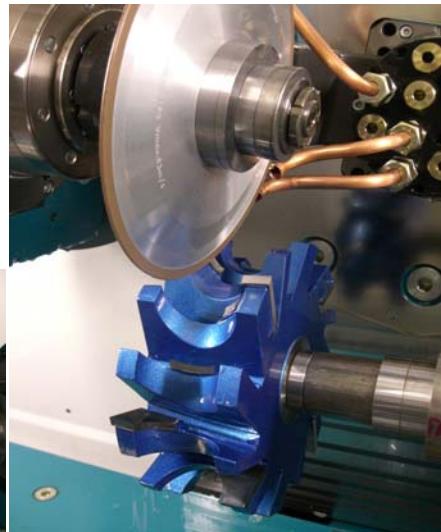


Profiled alternated Cutter Ø180 Z12

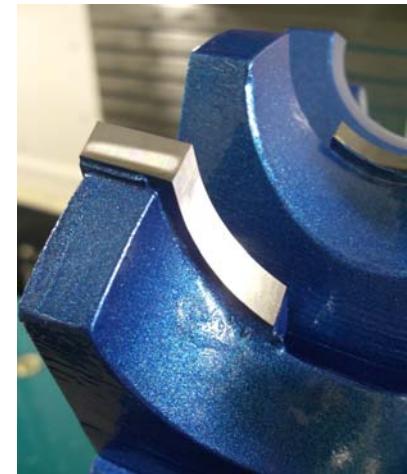
A16-210

The woodworking profiled cutter head with alternately inclined cutting edges is ground in one setup. The tool has totally 12 cutting edges, the complete roundbarprofile is subdivided into 3 cutting edges. In Quinto the tool is handled as 3 concatenated tools. Each of them is individually probed and overtakes one part of the profile. The cutting face is ground in 3 passes in a one axis movement (z-axis) .



1. Cycletime for Production

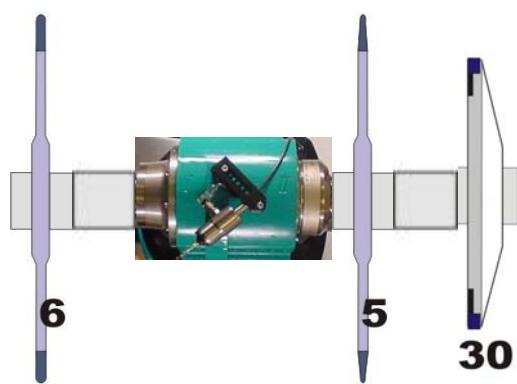
Tool specifications Ø180, altern. Shear angles 10/0/-10°, L70 mm, Z12 Material CARBIDE					
Operations	Probe	Flute 1	Prf Pregr 1	Prf Pregr 2	Prf fin
Feed [mm/Min]	2000	65	60	70	90
Power [kW]		4	2	1	1
Cutting feed [m/s]		18	24	24	24
Used wheels		30	6	6	5
Grinding time [s]	61	1899	1076	948	751
Total cycle time	78 Min 55				



The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

30 Ø150 12C9 D64
6 Ø200 14F1 D64
5 Ø200 14EE1 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.3, DXQ

responsible engineer: OP,8.1.08

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